

51

Date: Friday, 11/16/2007 7:20:14 AM
 User: Kim Johnston

Process Sheet

| | | | | | |
|-----------------------|--|--------------|----------------|-------------------------------|-----|
| Customer | CU-DAR001 Dart Helicopters Services | | Drawing Name | HELI-ACCESS STEP LH (FOLDING) | |
| Job Number | 35797 | | | | |
| Estimate Number | 12567 | | | | |
| P.O. Number | H/A | | Part Number | D412630033 | |
| This Issue | 11/16/2007 | S.O. No. N/A | Drawing Number | IIN D412-630 | |
| Prsht Rev. | NC | | Project Number | N/A | |
| First Issue | N/A | Type | LARGE FAB ASSY | Drawing Revision | L |
| Previous Run | 33998 | | | Material | N/A |
| Written By | | | Due Date | 12/20/2007 | |
| Checked & Approved By | J. Johnston | | Qty: | 3 Um: Each | |
| Comment | Est. Rev:A New Issue 06-11-08 JLM est rev B ech 1019, added d2807-041 EC verified by:DD | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description: | |
|---------|-----------------------|---|--|
| 1.0 | DC | DOCUMENT CONTROL | |
| | | Comment: DOCUMENT CONTROL Photocopy bluefile & create labels per PPP D412-630-033 CHG003 | |
| 2.0 | D2012107 | Clevis | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Clevis Pick: Qty Part Number Description Batch 1 D2012-107 Clevis B33585 X3 MF | |
| 3.0 | D2803041 | Bracket Assembly | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch 1 D2803-041 Bracket Assembly LH B2939/ X3 MF | |
| 4.0 | D2804041 | Bracket Assembly | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch 1 D2804-041 Bracket Assembly LH B27102/ B2756/ X3 07-11-28 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Friday, 11/16/2007 7:20:14 AM
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|---|-----------------------|--|---|
| Customer: CU-DAR001 Dart Helicopters Services | | | Drawing Name: HELI-ACCESS STEP LH (FOLDING) |
| Job Number: 35797 | | | Part Number: D412630033 |
| Job Number: | | | |
| Seq. #: | Machine Or Operation: | | Description : |
| 5.0 | D2807041 | | GAS SPRING ASSEMBLY |
| | | | |
| Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Support Prop Batch: B359620 | | | MF |
| 6.0 | D2813 | | Washer |
| | | | |
| Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Washer Pick: Qty Part Number Description Batch | | | B333578 MF |
| 7.0 | D3562041 | | STEP ASSEMBLY, LH |
| | | | |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Step Weldment LH Pick: Qty Part Number Description Batch | | | B35262 MF |
| 8.0 | D33951 | | Bushing |
| | | | |
| Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s) Bushing Pick: Qty Part Number Description Batch | | | B32783 MF |
| 9.0 | AN3C21A | | BOLT |
| | | | |
| Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) BOLT Pick: Qty Part Number Description Batch | | | M101189 MF |
| 10.0 | AN8C16 | | Bolt |
| | | | |
| Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Bolt Pick: | | | AD |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Friday, 11/16/2007 7:20:14 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 35797

Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation:

Description :

Qty Part Number Description
2 AN8C16 Bolt

Batch

1102734

(46)

mf

11.0 AN310C8 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick:

Qty Part Number Description
2 AN310C8 Nut

Batch

1104679

(46)

mf

12.0 MS24665302 Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Cotter Pin

Pick:

Qty Part Number Description
2 MS24665-302 Cotter Pin (or AN380C3-4)

Batch

116941

(46)

mf

13.0 NAS1515H3 Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty Part Number Description
6 NAS1515H3 Washer

Batch

1105764

(46)

mf

14.0 NAS1515H5L WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

WASHER

Pick:

Qty Part Number Description
4 NAS1515H5L Washer

Batch

1105728

(46)

mf

15.0 NAS1515H8 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

Pick:

Qty Part Number Description
4 NAS1515H8 Washer

Batch

1104811

(46)

mf 07-11-2008 X3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Friday, 11/16/2007 7:20:14 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 35797

Part Number: D412630033

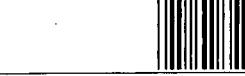
Job Number:



Seq. #: Machine Or Operation:

Description :

16.0 MS210433 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

| Qty | Part Number | Description |
|-----|-------------|-------------|
| 4 | MS21043-3 | Nut |

Batch

M105728

(112)

MF

17.0 MS24693C280 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

Pick:

| Qty | Part Number | Description |
|-----|--------------|-------------------------|
| 2 | MS24693-C280 | Screw (or MS24694-C565) |

Batch

M101390

(11)

MF 07-11-28

CBT/11/27(3)

18.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor
A/R LPS3 batch: M104929

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON BATCH: M17045

MF 07-11-28

(3)

19.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

X catalyst X3

20.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

X C 21.0 D28061 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

B32773 2P

Bushing

Pick: Packing Kit

| Qty | Part Number | Description |
|-----|-------------|-------------|
| 2 | D28061 | Bushing |

Batch

B33590 4P

C 7/11/28 (3)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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NOTE: Date & initial all entries

Date: Friday, 11/16/2007 7:20:14 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 35797

Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation:

Description :

2 D2806-1 Bushing

22.0 D28063 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number Description Batch
2 D2806-3 Bushing B29872

23.0 D28105 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number Description Batch
1 D2810-5 Strut B32775-2P

24.0 D33961 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number Description Batch
2 D3396-1 Spacer B29496

25.0 AN4C6A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number Description Batch
1 AN4C6A Bolt M105426

26.0 AN4C10A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number Description Batch
1 AN4C10A Bolt M121189

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Friday, 11/16/2007 7:20:14 AM
User: Kim Johnston

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|---|-----------------------|---------|---|
| Customer: CU-DAR001 Dart Helicopters Services | | | Drawing Name: HELI-ACCESS STEP LH (FOLDING) |
| Job Number: 35797 | | | Part Number: D412630033 |
| Job Number: | | | |
| Seq. #: | Machine Or Operation: | | Description : |
| 27.0 | AN4C15A | Bolt | |
| Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Bolt Pick: Packing Kit Qty Part Number Description Batch 2 AN4C15A Bolt M103918 | | | |
| 28.0 | AN44C7A | Eyebolt | |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Eyebolt Pick: Packing Kit Qty Part Number Description Batch 1 AN44-C7A Eyebolt M101711 | | | |
| 29.0 | AN5C15A | Bolt | |
| Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Bolt Pick: Packing Kit Qty Part Number Description Batch 2 AN5C15A Bolt M101291 | | | |
| 30.0 | NAS1515H4 | Washer | |
| Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s) Washer Pick: Packing Kit Qty Part Number Description Batch 7 NAS1515H4 Washer M104718 7X M10428 14 | | | |
| 31.0 | NAS1515H5 | Washer | |
| Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s) Washer Pick: Packing Kit Qty Part Number Description Batch 7 NAS1515H5 Washer M105728 7 M105752 17 | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/11/130
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Friday, 11/16/2007 7:20:14 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 35797

Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation:

Description :

32.0 MS210434 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick: Packing Kit

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------------|
| 4 | MS21043-4 | Nut | <i>M105432</i> |

M105432



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Nut

Pick: Packing Kit

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------------|
| 3 | MS21043-5 | Nut | <i>M105430</i> |

M105430



34.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

6/11/09 (3)

35.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-033

Location: *A*

PPP Rev: *A*

6/11/09 (3)

36.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

6/11/09 (3)

Job Completion



6/11/09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| Qty -033 | Qty -034 | Qty -243 | Qty -244 | Part Number | Description |
|----------|----------|----------|----------|--------------|---------------------------------|
| X | | | | D412-630-033 | HELI-ACCESS-STEP™ LH (FOLDING) |
| | X | | | D412-630-034 | HELI-ACCESS-STEP™ RH (FOLDING) |
| 1 | | X | | D412-630-243 | STEP ASSEMBLY LH |
| 1 | | X | | D412-630-244 | STEP ASSEMBLY RH |
| | | | | | |
| | | 1 | 1 | D2012-107 | CLEVIS |
| | | 1 | | D2803-041 | STA 84 BRACKET ASSEMBLY LH |
| | | | 1 | D2803-042 | STA 84 BRACKET ASSEMBLY RH |
| | | 1 | | D2804-041 | STA 155 BRACKET ASSEMBLY LH |
| | | | 1 | D2804-042 | STA 155 BRACKET ASSEMBLY RH |
| 2 | 2 | | | D2806-1 | BUSHING |
| 2 | 2 | | | D2806-3 | BUSHING |
| | | 2 | 2 | D2807-041 | GAS SPRING ASSEMBLY (WAS D2807) |
| 1 | 1 | | | D2810-5 | STRUT |
| | | 2 | 2 | D2813 | WASHER |
| | | 1 | | D3562-041 | STEP WELDMENT LH |
| | | | 1 | D3562-042 | STEP WELDMENT RH |
| | | 4 | 4 | D3395-1 | BUSHING |
| 2 | 2 | | | D3396-1 | SPACER |
| | | | | | |
| | | 2 | 2 | AN3C21A | BOLT |
| 1 | 1 | | | AN4C6A | BOLT |
| 1 | 1 | | | AN4C10A | BOLT |
| 2 | 2 | | | AN4C15A | BOLT |
| 1 | 1 | | | AN44-C7A | EYEBOLT |
| 2 | 2 | | | AN5C15A | BOLT |
| | | 2 | 2 | AN8C16 | BOLT |
| | | 2 | 2 | AN310C8 | NUT |
| | | 2 | 2 | MS24665-302 | COTTER PIN (OR AN380C3-4) |
| | | 6 | 6 | NAS1515H3 | WASHER |
| 7 | 7 | | | NAS1515H4 | WASHER |
| 7 | 7 | | | NAS1515H5 | WASHER |
| | | 4 | 4 | NAS1515H5L | WASHER |
| | | 4 | 4 | NAS1515H8 | WASHER |
| | | 4 | 4 | MS21043-3 | NUT |
| 4 | 4 | | | MS21043-4 | NUT |
| 3 | 3 | | | MS21043-5 | NUT |
| | | 2 | 2 | MS24693-C280 | SCREW (OR MS24694-C565) |

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Revision: L
Date: 07.09.30

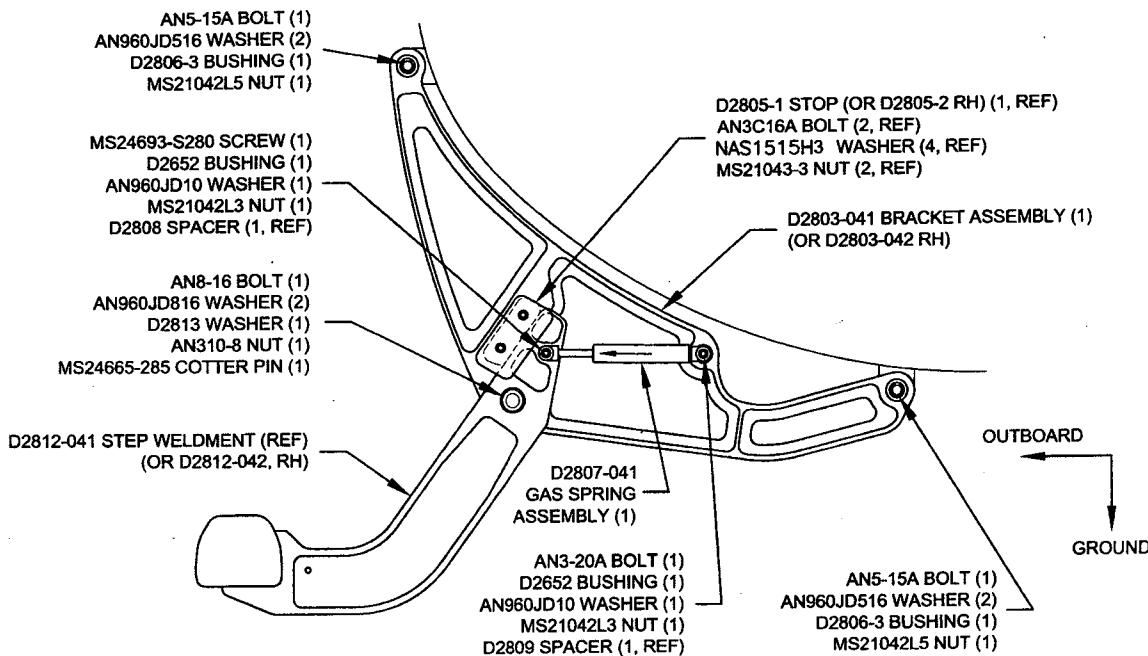
D412-630-011/-012 Heli-Access-Step™ Installation

FIGURE 4 – STA 84.29 for D412-630-011/-012 Heli-Access-Step™ Installation
(View rotated 90° CW)

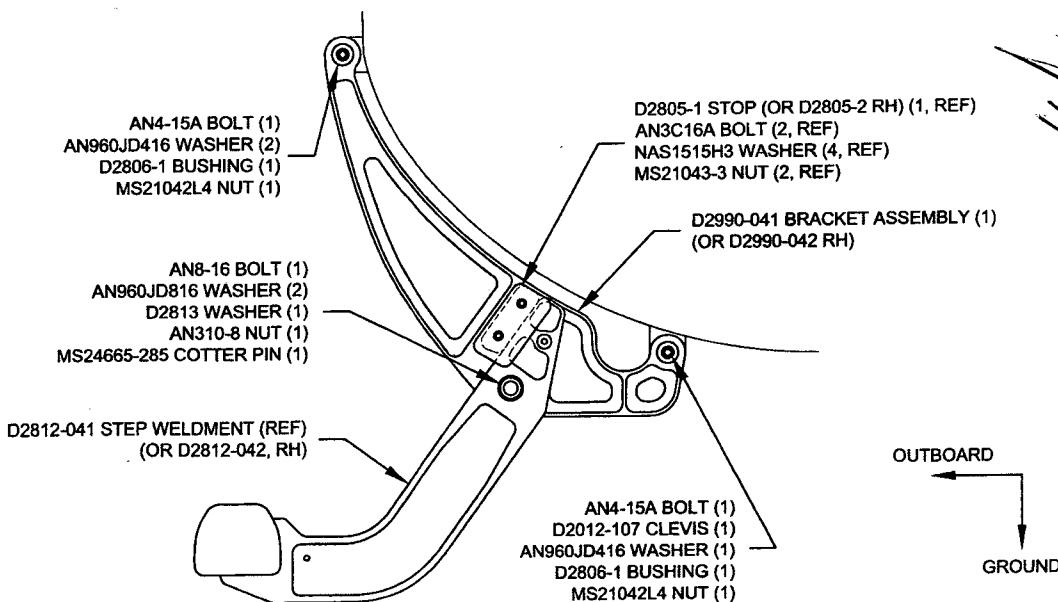
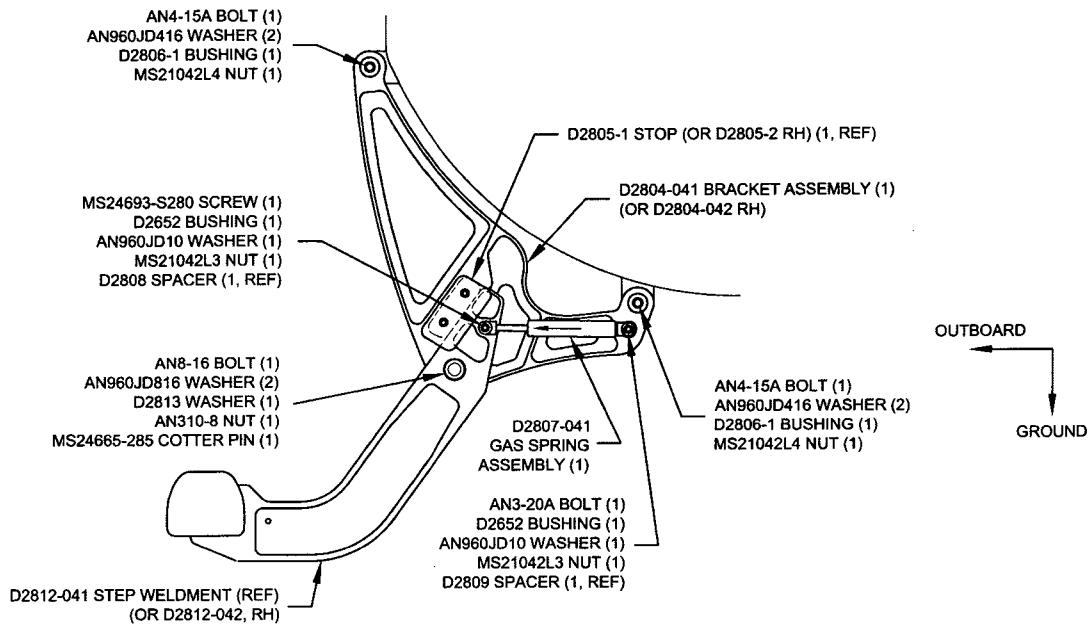


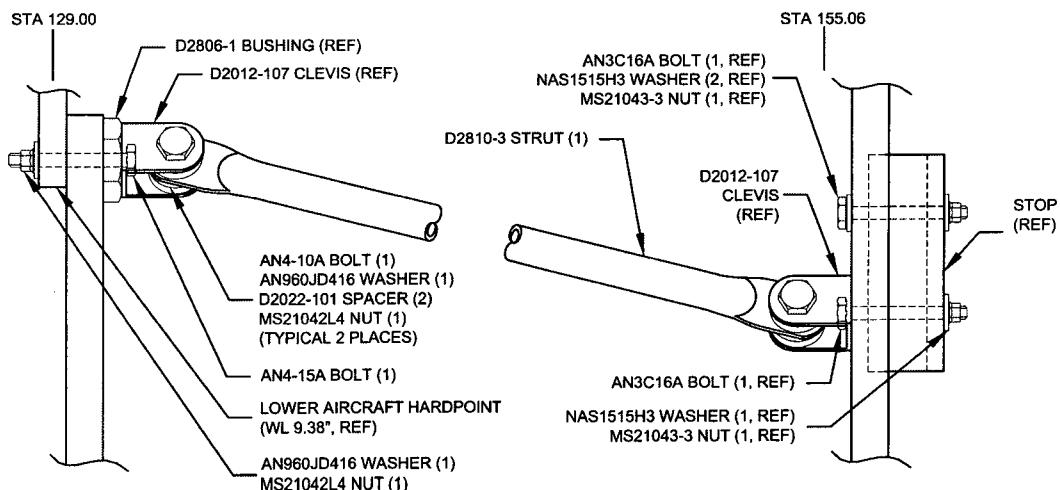
FIGURE 5 – STA 129.00 for D412-630-011/-012 Heli-Access-Step™ Installation
(View rotated 90° CW)

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Revision: L
Date: 07.09.30



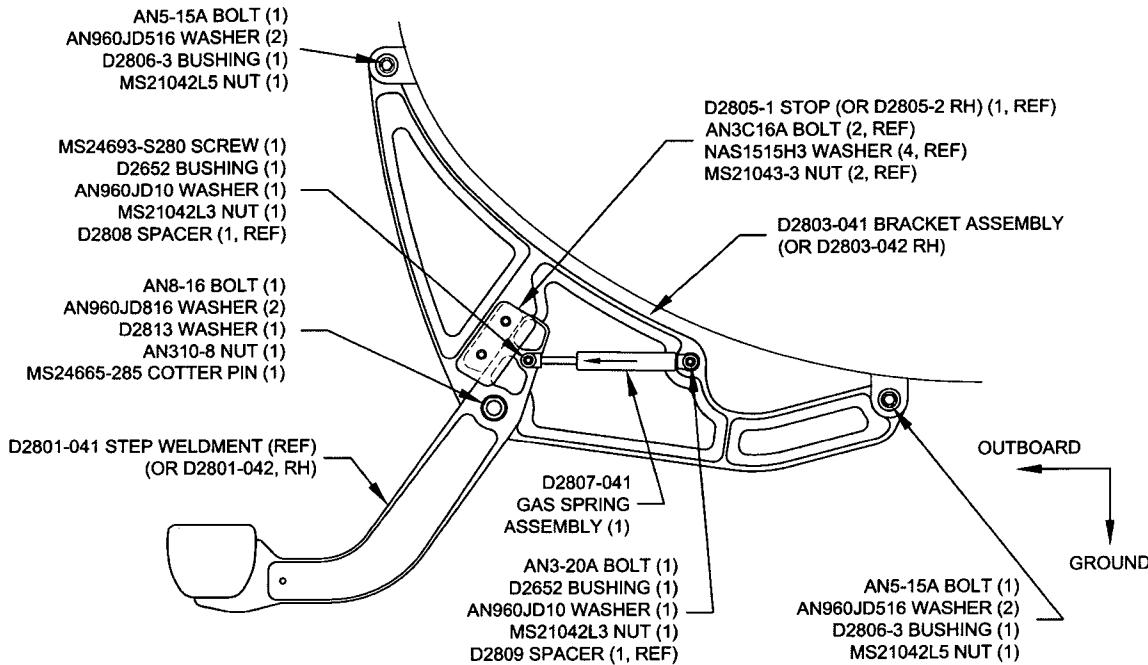
**FIGURE 6 – STA 155.06 for D412-630-011/-012 Heli-Access-Step™ Installation
(View rotated 90° CW)**



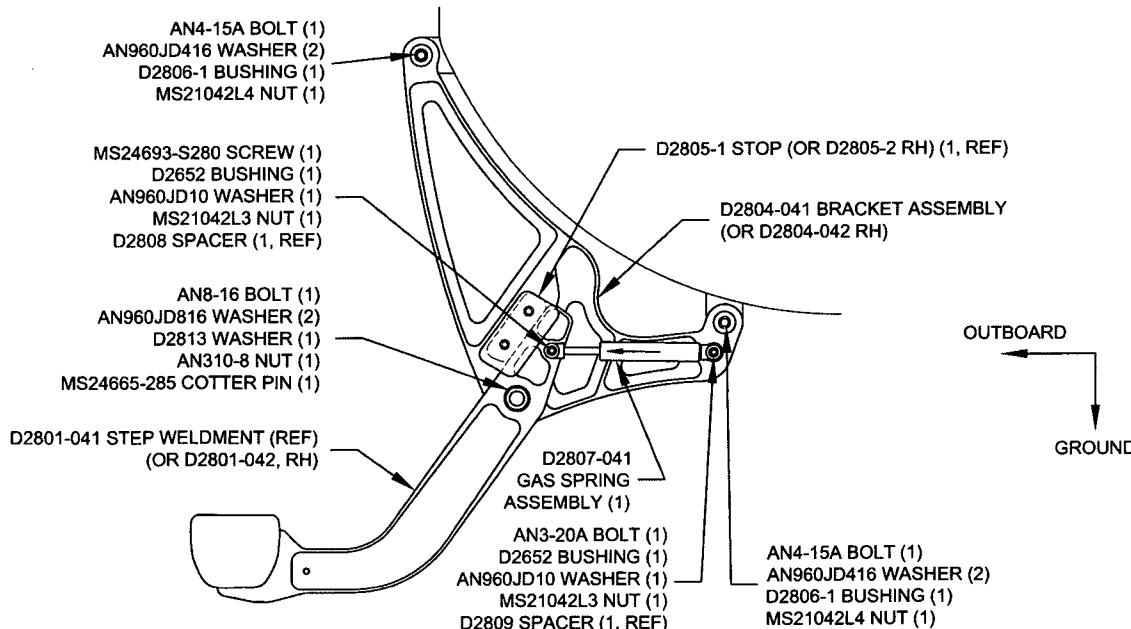
**FIGURE 7 – Strut Detail for D412-630-011/-012 Heli-Access-Step™ Installation
(NOT TO SCALE)**

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Revision: L
Date: 07.09.30

D412-630-013/-014 Heli-Access-Step™ Installation

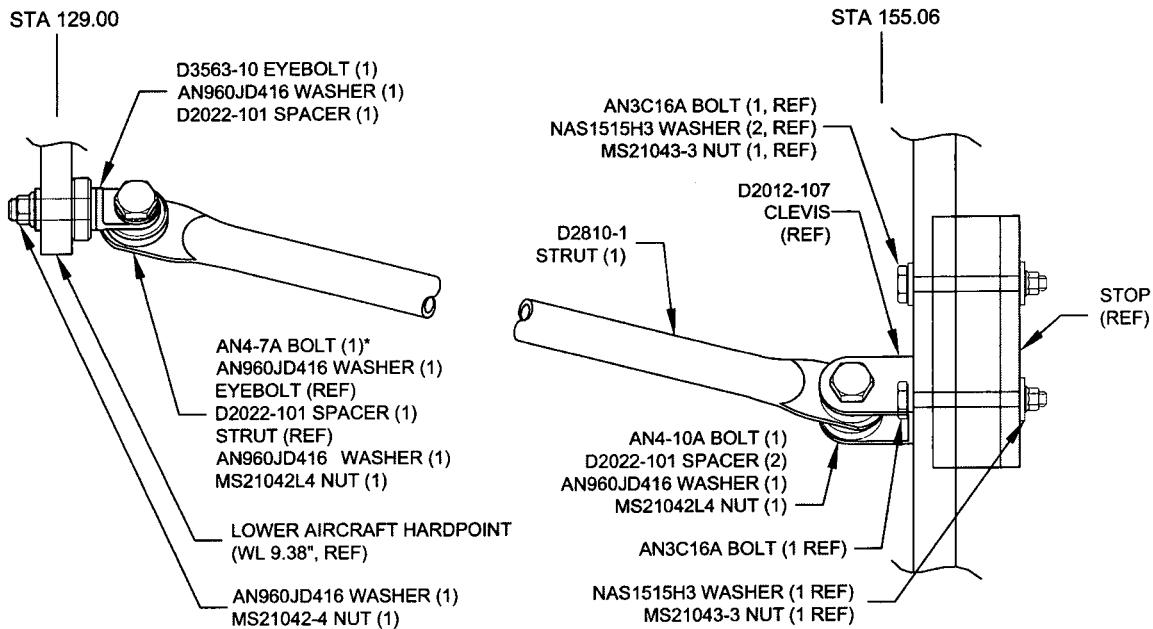
**FIGURE 8 – STA 84.29 for D412-630-013/-014 Heli-Access-Step™ Installation
(View rotated 90° CW)**



**FIGURE 9 – STA 155.06 for D412-630-013/-014 Heli-Access-Step™ Installation
(View rotated 90° CW)**

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Revision: L
Date: 07.09.30



* IF ADJUSTMENT OF THE STRUT IS REQUIRED TO AVOID OTHER HARDWARE ON THE AIRCRAFT, IT IS ACCEPTABLE TO USE LONGER AN4 BOLTS AND ADDITIONAL WASHERS AS REQUIRED TO ADJUST THE ATTACHMENT OF THE D2810-1 STRUT TO THE EYEBOLT.

**FIGURE 10 – Strut Detail for D412-630-013/-014 *Heli-Access-Step™* Installation
(NOT TO SCALE)**

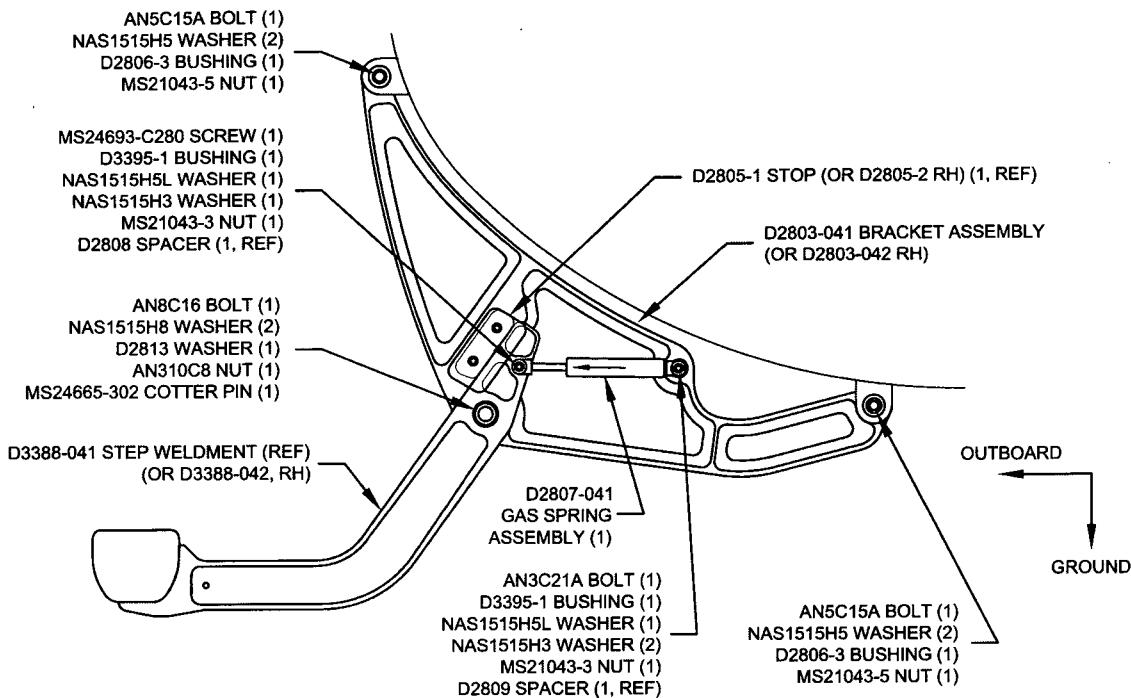
D412-630-023/-024 Heli-Access-Step™ Installation

FIGURE 11 – STA 84.29 for D412-630-023/-024 Heli-Access-Step™ Installation
(View rotated 90° CW)

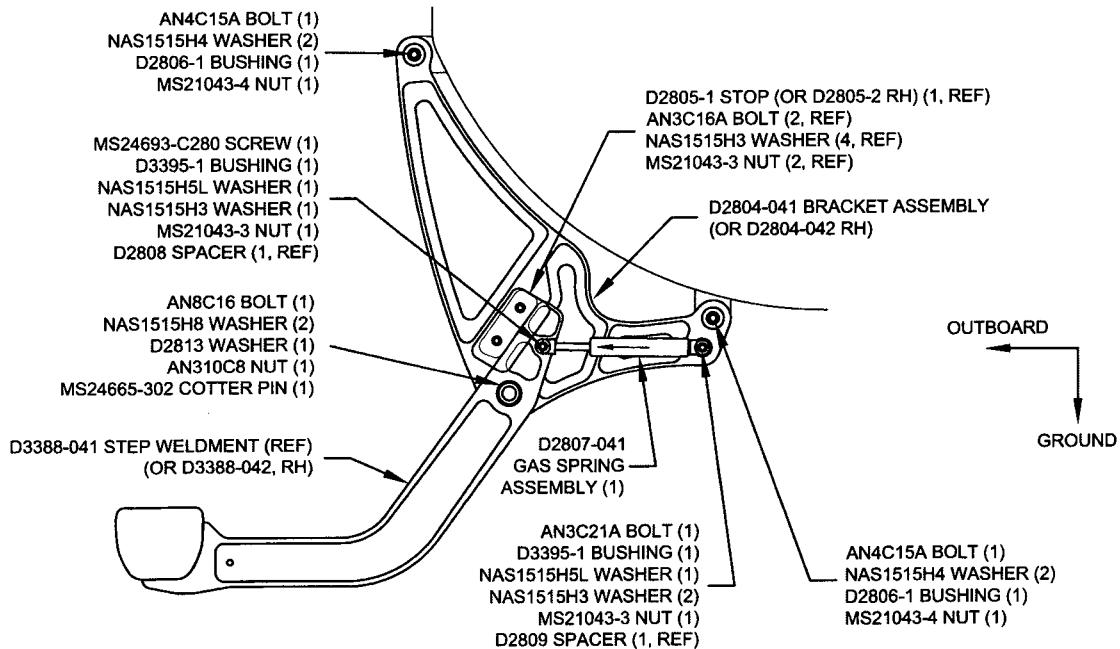


FIGURE 12 – STA 155.06 for D412-630-023/-024 Heli-Access-Step™ Installation
(View rotated 90° CW)

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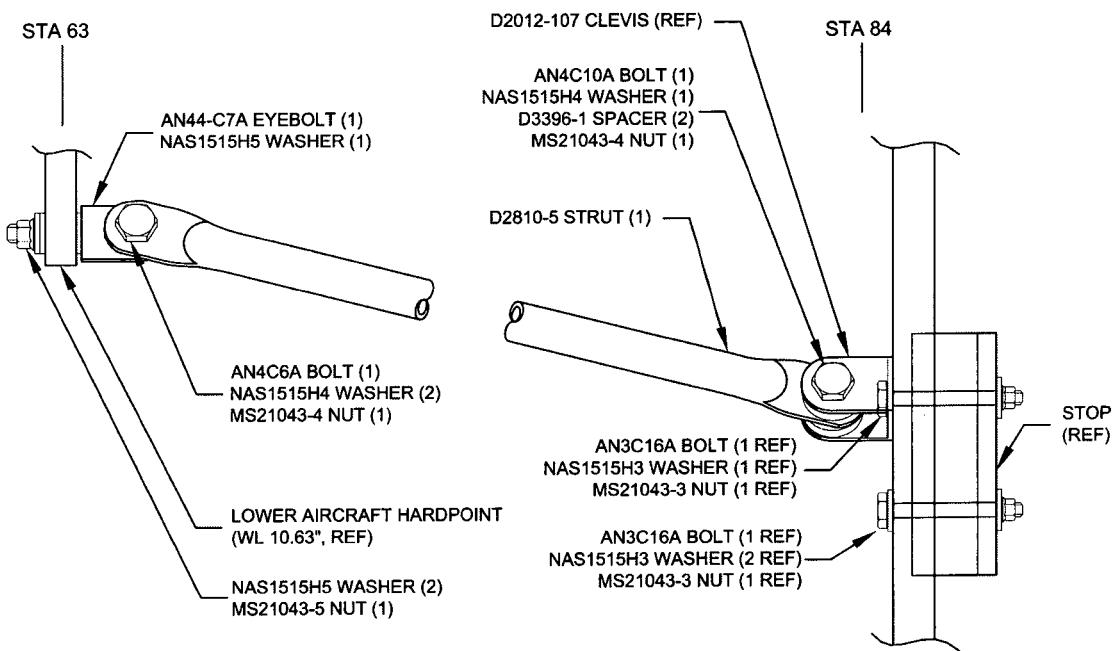


FIGURE 13 – Strut Detail for D412-630-023/-024 *Heli-Access-Step™* Installation
(NOT TO SCALE)

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